Aero Design Ltd.

Work Order Control Sheet

Work Order#: 2016-01 **Date Opened:** 04 Jan 2016 **Title:** Fabrication

Aircraft OEM: Eurocopter **Aircraft Model:** AS350/355 **Product Type:** Cargo Basket & Lid **Product Model:** XL **Quantity:** 1 / 1 (Modified)

Work Order Contents

	Initial or N/A
Work Order/Build Sheets (Procedures Provided)	JC
Additional Work Sheets (Standard Practice)	N/A
Drawings (See List Below)	JC
Parts Distribution Sheet	JC
Sub Component Tags	N/A
Completed Certification	N/A
Time Sheet (R&D)	N/A
Notes	N/A

Build Sheet Contents

	Initial or N/A
Tasks Initialled	JC
Dual Inspections Initialled	JC

Drawing List

Drawing #	Rev #	Description	Initial or N/A
94011	1	Body	JC
94012	1	Lid	JC
70405	4	Lid Walkway	JC
84262	2	Basket Handle Prov.	JC
84263	0	Lid Handle Provisions	JC
94090	0	Basket Body Mod.	JC
94091	0	Basket Lid Mod.	JC

Traveller

Initial or N/A

Component Completion

	As Instructed
Quantity Complete on This Work Order	1 / 1
Quantity Incomplete on This Work Order	N/A
Further Processing Required Before Release	N/A
Release to Stock as Components	N/A

Certification

	Initial or N/A
Form One Completed	N/A
Serviceable (Green) Tag Completed	N/A
In Process (Yellow) Tag Completed	JC
Unserviceable (Red) Tag Completed	N/A
Parts Tracking (White) Tag Completed	N/A
Parts Placed in Stores for Distribution	N/A

Additional Documentation

	Initial or N/A
Documentation of a minor change	N/A
Non-Conformance Report Required	N/A
Service Difficulty Report Required	N/A

Billing

	Initial or N/A
Local (Aero Design)	JR
Research and Development	N/A
Third Party	N/A

Work performed by:	Print: J. Clarke	Sign:	SCA: AD02	Date: 10-Feb-16	
ICC / Dual Inspection preformed by:	Print: J. Rekve	Sign:	SCA: AD01	Date: 12-Feb-16	
Work Order closed by:	Print: J. Clarke	Sign:	SCA: AD02	Date: 02-Mar-16	

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AMF 73-04

Nomenclature: BASKET LID No. of pieces: 1
Manufacturer: AERO DESIGN
Part No.: ~~94001~~ 94012-01 Serial/Batch No.: NSN
TTSN: N/A TSO: N/A Rem.: N/A
Work Order No.: 2016-01
Remaining Tasks to be Performed: POWDER COATING √JE.

Signature: JJ Cl.
Date: 12 FEB 2016 Lic. No. / SCA AD 02

Form# 20.E.03 Rev. 1 24 April 2014

In Process

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AMF 73-04

Nomenclature: BASKET BODY No. of pieces: 1
Manufacturer: AERO DESIGN
Part No.: 94011-01 Serial/Batch No.: NSN
TTSN: N/A TSO: N/A Rem.: N/A
Work Order No.: 2016-01
Remaining Tasks to be Performed: POWDER COATING √JE.

Signature: JJ Cl.
Date: 12 FEB 2016 Lic. No. / SCA AD 02

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In Process

Remarks

MODIFIED IAW 94092

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AMF 73-04

In Process

Remarks

MODIFIED IAW 94091

9016-01
AS350 XL
MODIFIED PER DWG 94012 R0

CARGO BASKET LID FABRICATION - COMMON

General

These instructions apply to all cargo basket lid assemblies. Refer to the following drawings, at the current revision, for dimensions and details:

Bell 206L/407 – Right side only
69812, Revision 3 – Standard Low Mounted Basket; Extra-Wide Low Mounted Basket
94612, Revision 0 – Extra-Wide Low Mounted Ski Basket
76612, Revision 0 – High Mounted Ski Basket

Eurocopter AS350/AS355 – left or right
77612, Revision 1 – Short Basket
69812, Revision 3 – Medium Basket (left and right)
78412, Revision 2 – Long Basket
94012, Revision 0 – Extra Large (ski) Basket

Robinson R44 – left or right
90612, Revision 0 – Standard Basket (left or right)

Bell 206B – right side only
80212, Revision 0 – Short Basket
80312, Revision 0 – Medium Basket
81112, Revision 0 – Long Basket

Bell 429 – right or left
95912, Revision 0 – Standard Basket

Bell Medium – left or right
75112, Revision 0 – Standard Basket
95512, Revision 0 – Extra Large (ski) Basket

MD600
82812, Revision 0 – Standard Basket

Options
70405, Revision 3 – Walkway
70402, Revision 1 – Lid Door

CARGO BASKET LID FABRICATION

Complete
(initial or SCA #)

Work Order: 2016-01

Date Open: 04 JAN 2016

1. Rim Assembly – Basket Lid — AD02
 a. Cut and fit ¾" x 0.035 material to fit rim jig, 45 degree ends.
 i. 1 or 2 lid prop bushing holes in short tube – refer to drawing
 b. Record material PO on attached material list.
 c. Remove writing on tubes with acetone and scotch bright.

2. Weld Rim Assembly — AD-05
 a. Record welding rod PO on attached material list.

3. Inspection — AD02
 a. Rim for complete welds

4. Frame assembly – Lid — AD02
 a. General
 i. Vent holes shall be #30 (0.129), and located inside the structure wherever possible to allow venting of weld gasses through existing holes (i.e. lid prop bushing)
 b. Insert rim from step 2 into jig.
 c. Cut and fit ¾" x 0.035 material, 21" long, for lid cross members.
 d. Record material PO on attached material list.
 e. Remove writing on tubes with acetone and scotch bright.
 f. Drill vent holes into rim to vent cross members into rim.
 g. Locate cross members in lid rim. Refer to drawing for spacing of cross members. Clamp cross members with C-clamps to jig.

5. Frame assembly – Lid with optional walkway modification — AD02
 a. Fit cross members to rim in accordance with step 4.
 b. Attach walkway jig with C-clamps. Ensure correct orientation of rim, refer to drawing.
 c. Cut ½" x 0.035 material for walkway stringers to fit between lid cross members. Record material PO on attached material list.
 d. Drill vent holes into cross members at walkway stingers.
 e. Align walkway stringers on walkway jig using cleco clamps near both ends of each stringer, and clamp stringer to jig using a C-clamp in the centre.

6. Weld frame assembly. — AD-05
 a. Record welding rod PO on attached material list.
 b. Jigs must remain in place for as long as practical during welding.

7. Inspection — AD02
 a. Frame assembly for complete welds.

8. Mesh assembly. AD02

 Note: 95912 (Bell 429) does not have mesh. Skip to step 10.

 a. Pull sheet of expanded mesh from stock. Record material PO on attached material list.
 b. Cut mesh to size for lid.
 c. Remove surface rust with scotch-brite.
 d. Ensure lid is prepared for mesh on the correct side.

9. Weld mesh to frame assembly per drawing. AD-05

 a. General welding requirements for all lids:
 i. Every intersection on all edges.
 ii. First 5 intersections along cross members, then every second intersection.
 b. MIG weld both short sides.
 c. Clamp lid over spacer at centre of lid to pre-tension mesh.
 i. ¾" for lids under 76"
 ii. 1" (check) for lids over 76"
 d. Weld remainder of mesh as indicated in a.
 e. Record welding rod PO on attached material list.

10. Weld lid components. AD-05

 a. Handle brackets, locate in accordance with drawing.
 i. Standard location: ¼" outside of last cross member on both ends.
 ii. Record handle bracket WO and welding rod PO on attached material list.
 b. Lid prop bushing(s).
 i. one or two in accordance with drawing.
 ii. Record lip prop bushing WO and welding rod PO on attached material list.
 c. Placard bracket. – not installed on 95912 (Bell 429)
 i. Locate on cross member to set bracket in centre bay of lid.
 ii. Record placard bracket WO and welding rod PO on attached material list.

11. Clean up AD02

 a. Grind high spots off mesh welds.
 b. Tighten mesh using special pliers. Tighten enough to remove "oil canning", where mesh springs in or out.
 c. Straighten lid using frame attached under welding table. Work carefully, avoid excessive force to prevent kinking rim tubes.
 d. Drill #9 through lid prop bushing(s). De-burr hole(s).
 e. Drill for lid bumpers using 1/4" (#3) centre drill.
 i. 3 places for lids under 76"
 ii. 4 places for lids over 76"
 f. Remove surface rust with scotch-brite pad.

12. Final Inspection

 To be completed by a different person than the previous steps. AD01

 a. Basket lid assembly for complete welds, and required minimum mesh weld locations.
 b. Material lists complete.
 c. Overall condition and conformity to drawing(s).

Complete
(initial or SCA #)

13. Powder Coating — AD02

 a. Parts are to be powder coated white in accordance with commercial practices.
 b. Record powder coating PO.
 c. Inspect powder coating on receiving.
 d. Tag lid assembly and place into stock in preparation for assembly.

2016-01
AS350 XL
MODIFIED PER DWG 94091 R0

CARGO BASKET BODY FABRICATION - COMMON

General

These instructions apply to all cargo basket body assemblies. Refer to the following drawings, at the current revision, for dimensions and details:

Bell 206L/407 – Right side only
69811, Revision 3 – Standard Low Mounted Basket
94511, Revision 0 – Extra-Wide Low Mounted Basket
94611, Revision 0 – Extra-Wide Low Mounted Ski Basket
76611, Revision 0 – High Mounted Ski Basket
Options 70404, Revision 2 – Front end cutout – 698
70411, Revision 0 – Front end cutout – 945/946

Eurocopter AS350/AS355 – left or right
77611, Revision 1 – Short Basket
76411, Revision 3 – Medium Basket (left or right)
78411, Revision 2 – Long Basket
94011, Revision 0 – Extra Large (ski) Basket
Options 70406, Revision 2 – Front end cutout – 764/776/784/940

Robinson R44 – left or right
90611, Revision 0 – Standard Basket (left or right)

Bell 206B – right side only
80211, Revision 0 – Short Basket
80311, Revision 0 – Medium Basket
81111, Revision 0 – Long Basket
Options 70406, Revision 2 – Front end cutout – 802/803/811

Bell 429 – right or left
95911, Revision 0 – Standard Basket

Bell Medium – left or right
75111, Revision 0 – Standard Basket
95511, Revision 0 – Extra Large (ski) Basket
Options 70407, Revision 1 – Front end cutout – 751
704 , Revision – Front end cutout – 955

MD600
82811, Revision 0 – Standard Basket

Options – Applicable to all models
70403, Revision 5 – Auxiliary Latch

CARGO BASKET BODY FABRICATION - COMMON **Complete** (initial or SCA #)

Work Order: 2016-01

Date Open: 04 JAN 2016

1. Rim Assembly – Basket Body AD02
 a. Cut and fit ¾" x 0.035 material to fit rim jig.
 i. 1 or 2 lid prop bushing holes in short tube – refer to drawing
 b. Record material PO on attached material list.
 c. Remove writing on tubes with acetone and scotch bright.
 d. For extra large baskets – drill #30 (0.129) vent holes to vent stringer tubes into rims.
 e. *94611 (206L/407 XL ski) only* – drill for 4 threaded bushings before assembling rim.

2. Weld Rim Assembly. AD-05
 a. Record welding rod PO on attached material list.
 b. *94611 (206L/407 XL ski) only* – weld 4 threaded bushings into inboard rim tube.

3. Inspection AD02
 a. Rim for complete welds

4. Frame assembly – body AD02
 a. General
 i. Vent holes shall be #30 (0.129), and located inside the structure wherever possible to allow venting of weld gasses through existing holes (i.e. lid prop bushing, hoops, etc.)
 b. Grind corner welds from step 2 on rim to allow hoops to sit flat.
 c. Pull required hoops from stock - standard, attachment, handle.
 i. If hoops are not in stock see detailed procedure sheet for specific hoop fabrication.
 ii. Ensure vent hole is located at centre of tube to vent spine tubes.
 d. Assemble hoops with attachment lug locating jig and hoop spacing jig.
 i. Ensure correct order and orientation of hoops. Refer to drawing.
 1. Attachment lugs are on inboard side.
 2. Handle bracket bushings are on outboard side, second hoop from both ends. May be on attachment hoops.
 ii. Run 3/8-24 tap into attachment lugs to ensure clear threads.
 iii. Bolt attachment lug locating jig to attachment hoops with 3/8-24 bolts.
 iv. Attach inboard and outboard hoop spacing jigs to all hoops using 1" C-clamps. Raise jigs approximately 2" off table to allow room to weld around hoops.
 v. Attach bottom (spine) jig to all hoops using 1" C-clamps along the centre line of the basket. Ensure jig is straight prior to tightening all clamps.
 e. Cut ½" x 0.035 material to fit spine jig.
 f. Cut ½" x 0.035 material for strut to fit from lower inboard attachment to upper outboard rim.
 i. Refer to applicable drawing for position, not required on some baskets.
 g. *Option*: Cut ½" x 0.035 material for front end cutout. Record material PO on attached material list.
 h. *90611 (R44) only*: Cut ½" x 0.035 material to fit front end structure. Record material PO on attached material list.
 i. Drill vent holes into attachment hoop and/or rim to vent strut(s) and front end cutout.

j. Record hoop WOs and material POs on attached material list.
k. Remove writing on tubes with acetone and scotch bright.
l. Insert rim assembly into jig and set frame assembly onto rim. Ensure correct orientation of lid prop bushings in rim to frame. Bushing hole must be closer to attachment side.
m. Align hoops to rim in accordance with drawing. General positions:
 i. Extra large baskets
 1. inboard side of hoops (attachment side) aligns to OUTSIDE of rim
 2. outboard side of hoops (handle side) aligns to INSIDE of rim
 3. forward and aft hoops align to INSIDE of rim
 ii. All other baskets
 1. inboard side of hoops (attachment side) aligns to INSIDE of rim
 2. outboard side of hoops (handle side) aligns to INSIDE of rim
 3. forward and aft hoops align to INSIDE of rim, except R44

5. TIG weld frame to rim assembly. AD-05
 a. Ensure lug locating jig and hoop locating jigs are in place. Jigs must remain in place for as long as practical during welding.
 b. Strut tubes and front end cutout (see step 4.f. and g.) must be welded in place after the hoops are welded to the rim. Jig(s) must be in place prior to welding strut tubes.
 c. Robinson R44 (90611) requires fitting and welding of forward end after remainder of basket frame is welded. Use jig to support front hoop.
 d. Record welding rod PO on attached material list.

6. Inspection AD02
 a. Frame assembly for complete welds.

7. Mesh assembly. AD02
 a. Pull sheet of expanded mesh from stock. Record material PO on attached material list.
 b. Cut mesh to size for body.
 c. Remove surface rust with scotch-brite.
 d. Bend body mesh – use table with bend markings on top. Lock wheels on table.
 i. For extra wide baskets only –
 1. Set ¾" angle along edge of table under mesh sheet. Set 1.5" square tube on top of mesh aligned with angle on edge of table. Clamp in place with 6" C-clamps.
 2. Bend upper edge of sheet just past a cell intersection to make a flange 2.5" - 3.25" wide. Closer to 2.5" is preferred, full cell intersection on flange side at bend is required.
 3. Bend down by hand as far as possible, then use a hammer to flatten the bend tight against the angle on the edge of the table.
 ii. Using markings on table, align sheet to indicated edge.
 iii. Using markings on table, align 3" tube to required position and clamp tube in place.
 iv. Bend mesh by hand tightly over tube along length of tube.
 v. Keeping mesh in place, un-clamp 3" tube, move to other position and clamp tube in place.
 vi. Bend mesh by hand tightly over tube along length of tube.
 e. Install attachment lug jig onto basket frame.

f. Ensure end struts are welded in basket frame if required by the drawing.
g. Insert mesh into basket.
 i. General
 1. Some cells may interfere with correct positioning, especially at the upper corners and around struts. Bend cell(s) in as required, do not cut cells off.
 2. Ideally welds will be located on mesh intersections. Shift mesh if possible to minimize welds located off mesh intersections.
 3. Ensure mesh reaches all edges of basket BEFORE trimming. Regardless of progress in clamping, remove clamps and shift mesh if required.
 4. Ensure cleco clamps are placed from the inside of the basket to allow removal during welding. Cleco clamps may be used from the outside during fitting, but must be removed prior to welding.
 ii. Extra large baskets only – seat corner of mesh with flange into inboard upper corner of frame. Use C-clamps on edge of flange as required to maintain tight fit.
 iii. Starting at inboard top edge of basket, clamp mesh to hoop near top rim using cleco clamps onto hoops. For regular size baskets, edge of mesh should sit approximately half way up rim tube.
 iv. Working down the inboard side, clamp mesh to hoops with cleco clamps. Clamp down into radius of hoop and continue clamping as required to maintain tight fit in corner of hoop. After the corners are tight, two clamps just onto the radius on both ends should be sufficient to hold the corner tight, remove all extra clamps.
 v. Clamp mesh to spine in at least 1 place per section.
 vi. Working up the outboard side, clamp the mesh into the radius of hoop and continue clamping as required to maintain tight fit in corner of hoop. After the corners are tight, 2 clamps just onto the radius on both ends should be sufficient to hold the corner tight, remove all extra clamps.
 vii. Trim upper outboard edge of mesh if required, edge of mesh must be low enough on rim tube to prevent the weld from protruding above the edge of the rim. Some sheets are tapered and may require ½ to 1 cell to be removed over some or all of the length of the basket. De-burr cut edges with a sanding disc on a die-grinder. Straighten cut cells with duck-bill pliers. Clamp mesh near upper edge to hoops with cleco clamps after trimming.
 viii. Trim ends to land on hoops, at mesh intersections if possible.
h. Cut mesh to fit ends. Record material PO on attached material list.
 i. Remove surface rust with scotch-brite.
 ii. Ensure mesh is cut at intersections where possible.
 iii. Bend top edge of mesh 1/8"-3/16" down at 45 degrees
 iv. Cut for front end cutout if required.
i. 90611 (R44) only: Cut mesh to fit upper forward end. Record material PO on attached material list.
 i. Remove surface rust with scotch-brite.
 ii. Ensure mesh is cut at intersections where possible.
 iii. Bend top edge of mesh 1/4" down at 60 degrees.
 iv. Fit mesh to front end of basket.

Complete (initial or SCA #)

8. Weld mesh to frame assembly per drawing. AD-05
 a. Ensure lug locating jig is in place prior to welding.
 b. General welding requirements for all baskets, MIG welding:
 i. Every intersection at top edges.
 ii. Every intersection at ends.
 iii. First 5 intersections down on hoops, then every second intersection.
 iv. Every intersection along spine.
 v. Extra large baskets – every intersection along corner.
 vi. Every intersection around ends
 vii. Every intersection along struts (if applicable)
 c. Bend and trim cells bent in to fit mesh as required and weld in position.
 d. Grind high spots off body mesh welds on ends before welding end mesh.
 e. *90611 (R44) only* – weld lid prop bushing (step 9) into rim BEFORE welding upper mesh on forward end of basket assembly.
 f. Record welding rod PO on attached material list.

9. Weld basket components AD-05
 a. TIG weld lid prop bushing(s), one or two per drawing.
 i. Record welding rod PO on attached material list.
 ii. Record lip prop bushing WO on attached material list.
 b. TIG weld caps to close top of 1" hoops as applicable.
 c. 94611 (Bell206L/407 XL ski) only: cut rim over cross tube gap.
 i. Cut inboard rim on aft end. Grind flush with hoops.
 ii. TIG weld caps on open tubes.
 iii. Record cap material PO on attached material list.
 d. 95911 (Bell 429) only: placard bracket to forward upper corner of basket.
 i. Record welding rod PO on attached material list.
 ii. Record placard bracket WO on attached material list.

10. Clean up AD 02
 a. Grind high spots off mesh welds.
 b. Tighten mesh using special pliers. Tighten enough to remove "oil canning", where mesh springs in or out. Do not tighten in corners of hoops, mesh will be deformed.
 c. Drill #9 through lid prop bushing(s). De-burr hole(s).
 d. Remove surface rust with scotch-brite pad.

11. Final Inspection AD01
 To be completed by a different person than the previous steps.
 a. Basket body assembly for complete welds, and required minimum mesh weld locations.
 b. Filled vent holes – usually on hoops
 c. Overall condition and conformity to drawing(s).
 i. Hoops for height.
 ii. Rim for width and length and alignment.
 iii. Lid prop lugs in correct ends.
 iv. Fore/aft strut in hoop if required by drawing.
 d. Material lists complete.

Complete
(initial or SCA #)

e. Tag complete basket body assembly in preparation for powder coating. ADO2

12. Powder Coating
 a. Parts are to be powder coated white in accordance with commercial practices.
 b. Record powder coating PO.
 c. Inspect powder coating on receiving.
 d. Tag basket body assembly and place into stock in preparation for assembly.

Work Order: 2016-01

Date Opened: 04 JAN 2016

Material Tracking Sheet
Eurocopter AS350 / AS355
Extra Large Basket Body Fabrication

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
	1	94011	**94011-01**	**Basket Assembly**		
Step 1				*Rim Assembly*		
	. 2		--	3/4" Tube - Long Rim (97")	4130 Steel, ¾" x 0.035 Sqr. Tube	
	. 2		--	3/4" Tube - Short Rim (25.5")	4130 Steel, ¾" x 0.035 Sqr. Tube	
	. 1		--	3/4" Tube - Long Stringer (95.5")	4130 Steel, ¾" x 0.035 Sqr. Tube	
	. 4		--	3/4" Tube - Short Stringer (2.25")	4130 Steel, ¾" x 0.035 Sqr. Tube	
Step 2				*Weld Rim Assembly*		
	. A/R		--	Welding Rod	ER70S-2 TIG Rod	
Step 3				*Inspection - Rim*	*None*	
Step 4				*Frame Assembly*		
	. 4		94030-01	Hoop - standard	4130 Steel, ½" x 0.035 Sqr. Tube	
	. 2		94023-01	Hoop - attachment		
	. 5		--	1/2" Tube - spine	4130 Steel, ½" x 0.035 Sqr. Tube	
Step 4.g.		70406	70406-01	*Option: Front End Cutout*		
			70406-03	1/2" Tube	4130 Steel, ½" x 0.035 Sqr. Tube	
			70406-04	1/2" Tube	4130 Steel, ½" x 0.035 Sqr. Tube	
Step 5				*Weld Frame Assembly*		
	. A/R		--	Welding Rod	ER70S-2 TIG Rod	
Step 6				*Inspection - Frame Assembly*	*None*	
Step 7				*Mesh Assembly*		
	. 1		--	Mesh (Body - 56" x 96")	3/4-16F Expanded Mild Steel sheet	
	. 2		--	Mesh (End - 25" x 18")	3/4-16F Expanded Mild Steel sheet	

Work Order: 2016-01

Date Opened: 04 JAN 2016

Material Tracking Sheet
Eurocopter AS350 / AS355
Extra Large Basket Body Fabrication

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
Step 8				*Weld Mesh*		
	. A/R		–	Welding Rod	ER70S-6 MIG Wire	
Step 9				*Weld Basket Components*		
	. 2		49215-01	Spacer (Lid prop)	304 Stainless Steel, ½" Dia.	
	. A/R		–	Welding Rod	ER308L TIG Rod	
Step 10				*Clean Up*	*None*	
Step 11				*Inspection - Final Assembly*	*None*	
Step 12				Powder Coating		

Work Order: 2016-01

Date Opened: 04 JAN 2016

Material Tracking Sheet
Eurocopter AS350 / AS355
Extra Large Lid Fabrication

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
	1	94012	**94012-01**	**Lid Assembly**		
Step 1				*Rim Assembly*		
	. 2		--	3/4" Tube - Long Rim (97")	4130 Steel, ¾" x 0.035 Sqr. Tube	
	. 2		--	3/4" Tube - Short Rim (22.5")	4130 Steel, ¾" x 0.035 Sqr. Tube	
Step 2				*Weld Rim Assembly*		
	. A/R			Welding Rod	ER70S-2 TIG Rod	
Step 3				*Inspection - Rim*	*None*	
Step 4				*Frame Assembly*		
	. 4		--	3/4" Tube - Cross Member (21")	4130 Steel, ¾" x 0.035 Sqr. Tube	
Step 5		70405		*Option: Frame Assembly - with walkway*		
	. 10		--	1/2" Tube - walkway	4130 Steel, ½" x 0.035 Sqr. Tube	
Step 6				*Weld Frame Assembly*		
	. A/R			Welding Rod	ER70S-2 TIG Rod	
Step 7				*Inspection - Frame Assembly*	*None*	
Step 8				*Mesh Assembly*		
	. 1		--	Mesh (lid - 96" x 22")	3/4-16F Expanded Mild Steel sheet	
Step 9				*Weld Mesh*		
	. A/R			Welding Rod	ER70S-6 MIG Wire	

Work Order: 2016-01

Date Opened: 04 JAN 2016

Material Tracking Sheet
Eurocopter AS350 / AS355
Extra Large Lid Fabrication

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
Step 10				*Weld Lid Components*		
	. 1	84262	84262-01	Upper Handle Bracket Assembly		
	. . 4		36273-01	Lid Bracket	321 Stainless, 0.050 Sheet	
	. . 2		36275-02	Support	304 Stainless, 5/16" Rod	
	. A/R			Welding Rod	ER308L TIG Rod	
	. 2		49216-01	Spacer (Lid prop)	304 Stainless, ½" Dia.	
	. A/R			Welding Rod	ER308L TIG Rod	
	. 1		36204-10	Placard Bracket	1018 Steel, 0.035" Sheet	
	. A/R			Welding Rod	ER70S-2 TIG Rod	
Step 11				*Clean Up*		
Step 12				*Inspection - Final Assembly*		
Step 13				Powder Coating		

Aero Design

Parts Distribution Sheet

Description: AS350 XL Stl Modified WO# 2016-01

From PO or WO #	Quantity	Description	Part Number	For WO #
2014-38	2	lid handle mounts	84363-02	
15061	1	Placard bracket	36204-10	
2015-84	2	Spacer	49216-01	
15037	1	Mesh for lid	3/4-16F	
14099	1	3/4" x .035" tube		
14005	1	ER 705 welding rod.		
15059	1	705 Mig wire		
14028	1	ER308L		
2015-74	4	hoops	94030-01	
2015-74	2	½ transition hoop		
15015	2	1" transition hoop.		
~~94023-07~~ 2015-108	2	bushing	94023-07	
~~94023-05~~ 2015-108	2	bushing	94023-05	
14099		½ x ¾ x .035		
14045	Not used	1/8 Aluminum sheet	Jig for welding	
16003	4'X4'	YS 6061-T6 plate	panels.	
16003	2@11x11	0.050 6061-T6 sheet		
15024	12@3¼"	5/16" x 0.035 4130 TUBE		
15024	38@½"	BUSHING	84272-01	
15037	1	MESH (BODY)	3/4-16P	
2015-84	2	SPACER	49215-01	
16011	1	POWDER COAT		

1" Hoop Bend

Requirements
*Review LOED to ensure most up to date specifications.
* Cut 33 3/8. – from long end of 60° to short end of 16°
*Cut one end at 16 degrees and the other at 60 degrees.
* At the 16 degree end measure up 21 1/8 and mark. ✓
* Line up the mark on the radius of the bender and bend.
* Lower stop to 101 degree

maybe not, seems to be too long. ✓

→ long end to long end *

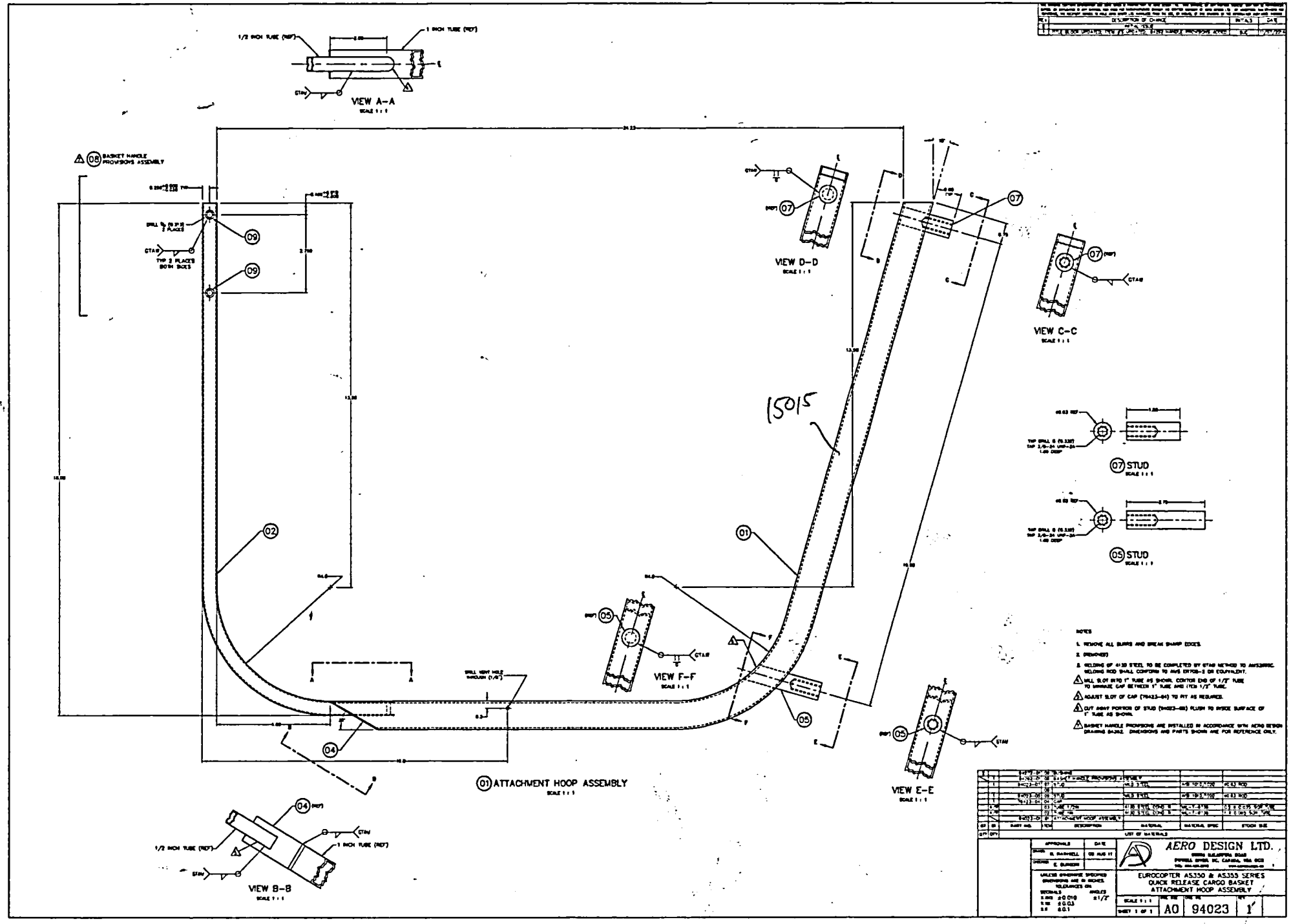
outside edge

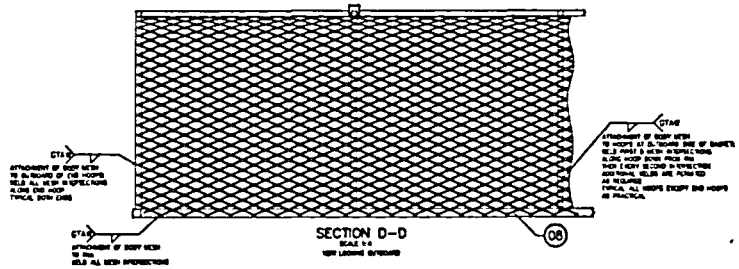
* 99° from ∅-mark on bender stop (not far enough)

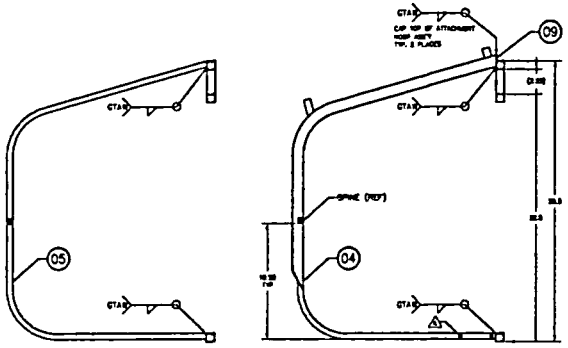
100° – for these 2 matches hoops (1/2")

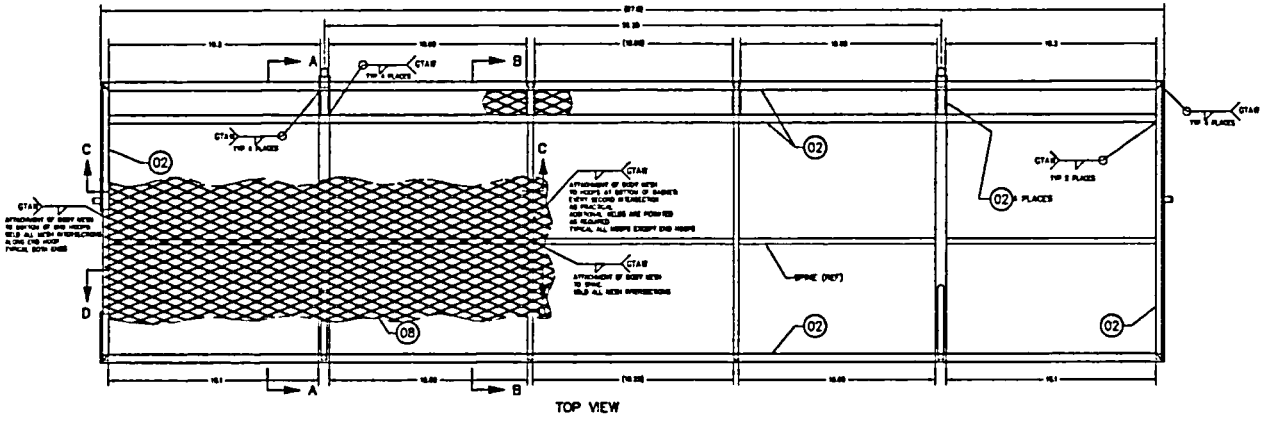
→ line up the mark on the tube with the mark on the edge of the bender mandrel

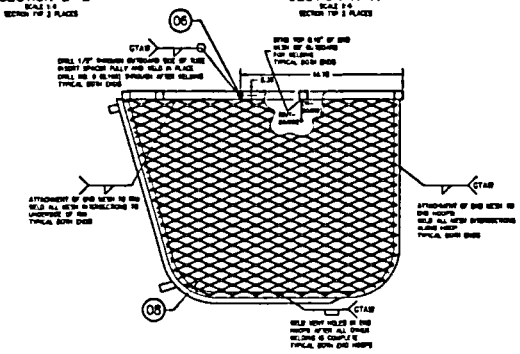
60° end ~~out~~ sticking out of gripper

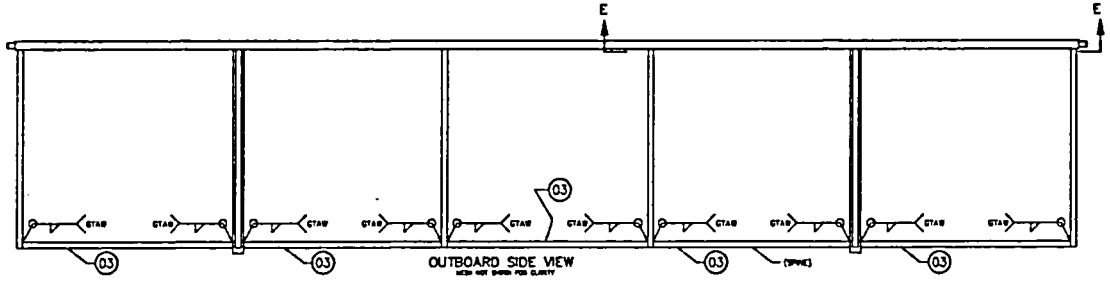

VIEW A-A
SCALE 1 : 1
VIEW D-D
SCALE 1 : 1
VIEW C-C
SCALE 1 : 1
07 STUD
SCALE 1 : 1
05 STUD
SCALE 1 : 1
VIEW F-F
SCALE 1 : 1
VIEW E-E
SCALE 1 : 1
VIEW B-B
SCALE 1 : 1
01 ATTACHMENT HOOP ASSEMBLY
SCALE 1 : 1
08 BASKET HANDLE PROVISIONS ASSEMBLY
15015
NOTES
1. REMOVE ALL BURRS AND BREAK SHARP EDGES.
2. (REMOVED)
3. WELDING OF 4130 STEEL TO BE COMPLETED BY GTAW METHOD TO AMS5896. WELDING ROD SHALL CONFORM TO AMS 5870B-3 OR EQUIVALENT.
4. MILL SLOT INTO 1" TUBE AS SHOWN. CONTOUR END OF 1/2" TUBE TO MINIMIZE GAP BETWEEN 1" TUBE AND 1"X3 1/2" TUBE.
5. ADJUST SLOT OF CAP (79423-04) TO FIT AS REQUIRED.
6. CUT AWAY PORTION OF STUD (94023-05) FLUSH TO INSIDE SURFACE OF 1" TUBE AS SHOWN.
7. BASKET HANDLE PROVISIONS ARE INSTALLED IN ACCORDANCE WITH AERO DESIGN DRAWING 84363. DIMENSIONS AND PARTS SHOWN ARE FOR REFERENCE ONLY.
AERO DESIGN LTD.
EUROCOPTER AS350 & AS355 SERIES
QUICK RELEASE CARGO BASKET
ATTACHMENT HOOP ASSEMBLY
SIZE A0
DWG NO 94023
REV 1
SCALE 1 : 1
SHEET 1 OF 1



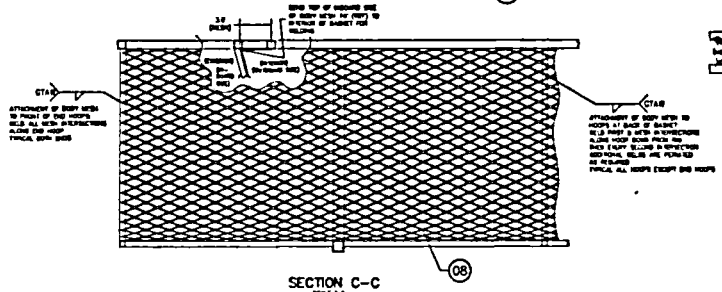


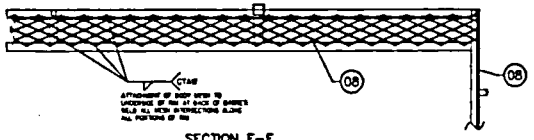






01 BASKET BODY ASSEMBLY





NOTES

1. REMOVE ALL BURRS AND BREAK SHARP EDGES
2. PRIOR TO WELDING, DRILL ADD (R1/8) VENT HOLES IN ASSEMBLY FOR VENTING OF WELD GASES. WHEN ASSEMBLY IS COMPLETE, FILL ALL EXPOSED VENT HOLES WITH ROSETTE WELDS.
3. WELDING OF ALUM STEEL TO BE COMPLETED BY GTAW METHOD TO AWS D1.2/D1.2M AND 1090 STEEL WELDING ROD SHALL CONFORM TO DTF90-2 OR EQUIVALENT. STAINLESS AND M 20 STEEL WELDING ROD SHALL CONFORM TO ER308L OR EQUIVALENT.
4. INSTALL PER 7 BASKET PANELS PROPERLY ASSEMBLY IN ACCORDANCE WITH AERO DESIGN LTD. DRAWING 94000 BEFORE WELDING HOOPS TO RAIL.
5. FINISH THOROUGHLY CLEAN AND POWDER COAT BASKET ASSEMBLY.

ITEM	PART NO.	QTY	DESCRIPTION	MATERIAL/SIZE	MATERIAL SPEC	STOCK SIZE
			LIST OF MATERIALS			

REV	DESCRIPTION OF CHANGE	INITIALS	DATE
	INITIAL RELEASE		
	ADDED LOCATING HOLES AND UPDATED REFERENCE DRAWINGS	EJE	17/07/2013
	ADDED DRILL & WELD NOTE	EJE	17/07/2013

APPROVALS	DATE
DRAWN: E. BURDEN	08 AUG 11
CHECKED: E. BURDEN	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES ON:
DECIMALS: .XXX ±0.010, .XX ±0.03, .X ±0.1
ANGLES: ±1/2°

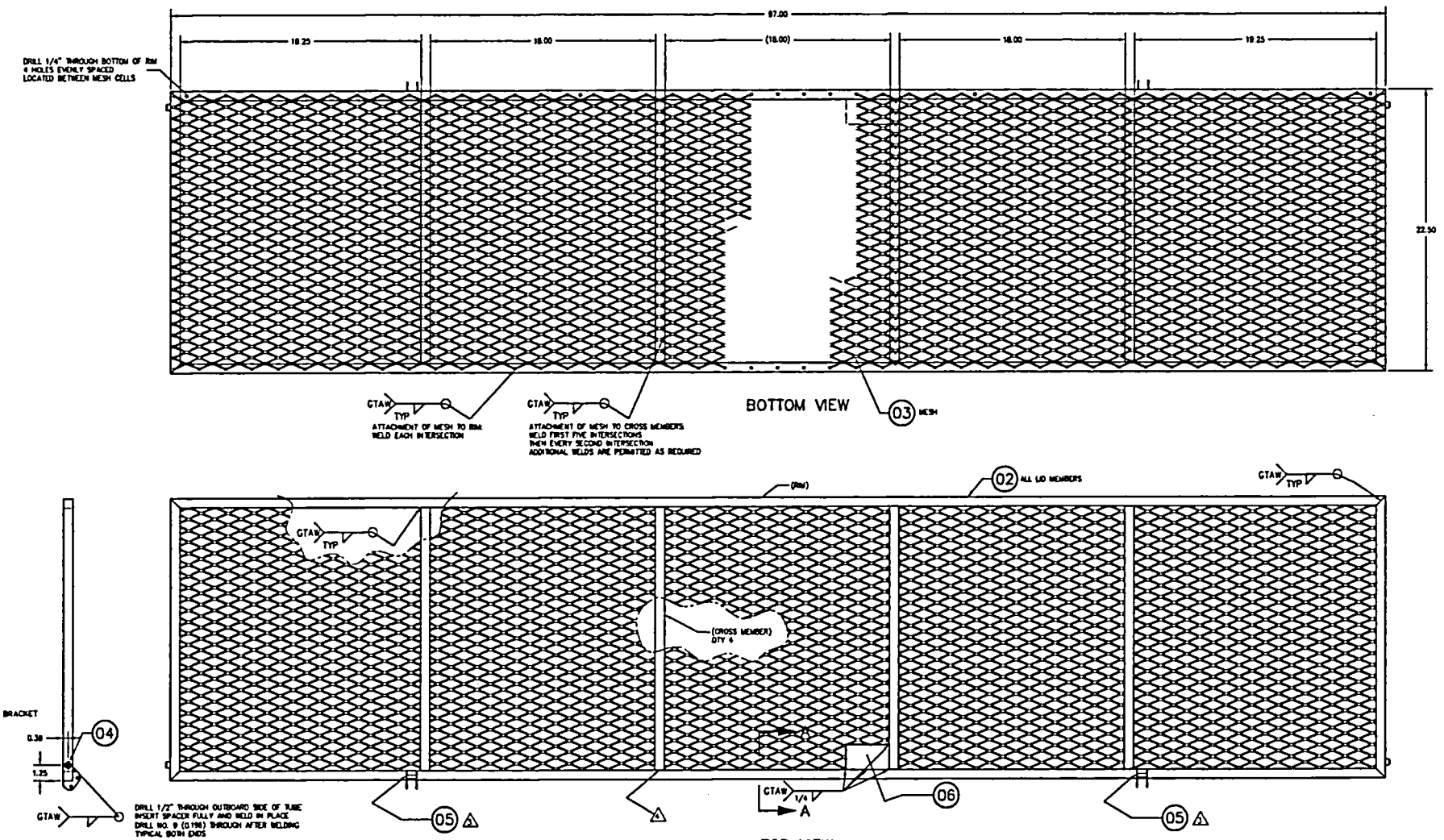
AERO DESIGN LTD.
UNIT 3, KINGSFORD ROAD
PITT MEADOWS, BC, CANADA, V3Y 2N5
TEL: 604.465.6676 WWW.AERODESIGN.CA

EUROCOPTER AS350 & AS355 SERIES
QUICK RELEASE CARGO BASKET
BASKET BODY ASSEMBLY (EXTRA LARGE)

SCALE	SIZE	DWG NO.	REV
1 : 4	A0	94011	1
SHEET 1 OF 1			

THIS DRAWING CONTAINS INFORMATION AND DATA WHICH IS PROPRIETARY TO AERO DESIGN LTD. THIS DRAWING, OR ANY PORTION THEREOF, MAY NOT BE REPRODUCED, COPIED OR DUPLICATED IN ANY MANNER, NOR USED FOR MANUFACTURING WITHOUT THE WRITTEN CONSENT OF AERO DESIGN LTD. BY ACCEPTING THIS DRAWING FOR REFERENCE, THE RECIPIENT AGREES TO HOLD AERO DESIGN LTD. HARMLESS FROM THE USE, OR MISUSE, OF THIS DRAWING OR THE INFORMATION CONTAINED THEREON.

REV	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		
1	TITLE BLOCK UPDATED; CHANGED 36273-01 TO 84263-01; ITEM #5 ADDED	BJC	10/07/2014
	WELDING ROD UPDATED; # OF WELDS DOWN BRACE TUBES INCREASED		



01 LID ASSEMBLY

QTY	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
1	36204-10	08	PLACARD BRACKET			
1	84263-01	05	LID HANDLE PROVISIONS ASSEMBLY			
2	49216-01	04	SPACER			
A/R	3/4 - 16F	03	MESH	MILD STEEL	COMMERCIAL	
A/R		02	SQUARE TUBE	4130 STEEL COND N	MIL-T-6736	0.75 X 0.035 SQR TUBE
	94012-01	01	LID ASSEMBLY			

LIST OF MATERIALS

NOTES:
1. REMOVE ALL BURRS AND BREAK SHARP EDGES.
2. WELDING OF 4130 STEEL TO BE COMPLETED BY GTAW METHOD TO AMS 2685C.
 4130 AND 1018 STEEL: WELDING ROD SHALL CONFORM TO ER70S-2 OR EQUIVALENT.
 STAINLESS AND 4130 STEEL: WELDING ROD SHALL CONFORM TO ER308L OR EQUIVALENT.
3. INSTALL ITEM 5 (LID HANDLE PROVISIONS ASSEMBLY) IN ACCORDANCE WITH AERO DESIGN LTD. DRAWING 84263.
4. DRILL ⌀30 (0.129) HOLES IN LONG TUBE MEMBERS AT BRACE LOCATIONS TO VENT WELD GASSES. WHEN ASSEMBLY IS COMPLETE, FILL ALL EXPOSED VENT HOLES WITH ROSETTE WELD.
5. FINISH: THOROUGHLY CLEAN AND POWDER COAT LID ASSEMBLY.

APPROVALS	DATE
DRAWN: R. MARSHALL	05 AUG 11
CHECKED: E. BURGOIN	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES.
TOLERANCES ON:
DECIMALS: X XXX ±0.010; X XX ±0.03; X X ±0.1
ANGLES: ±1/2°

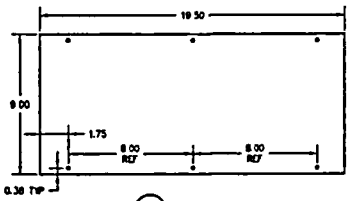
AERO DESIGN LTD.
8688A MALASPINA ROAD
POWELL RIVER, BC, CANADA, V8A 0G3
TEL: 604.485.5878 www.aerodesign.ca

EUROCOPTER AS350 & AS355 SERIES
QUICK RELEASE CARGO BASKET
LID ASSEMBLY (EXTRA LARGE)

SCALE 1 : 4	DWG. SIZE	DWG. NO.	REV.
SHEET 1 OF 1	A1	94012	1

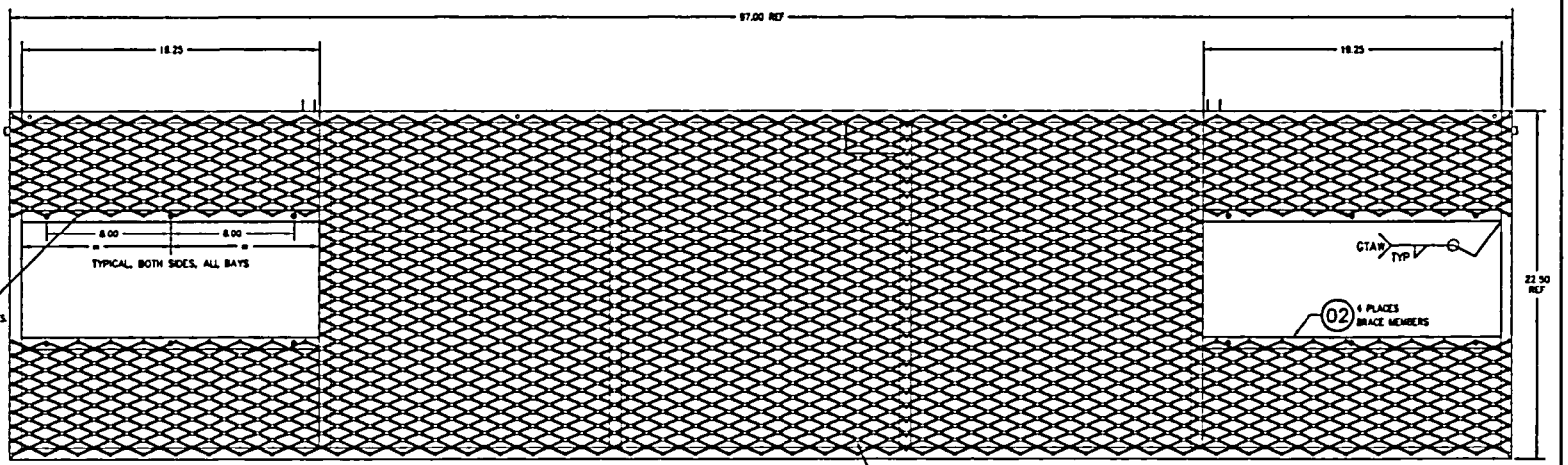
THIS DRAWING CONTAINS INFORMATION AND DATA WHICH IS PROPRIETARY TO AERO DESIGN LTD. THIS DRAWING, OR ANY PORTION THEREOF, MAY NOT BE REPRODUCED, COPIED, OR DUPLICATED IN ANY MANNER, NOR USED FOR MANUFACTURING WITHOUT THE WRITTEN CONSENT OF AERO DESIGN LTD. BY ACCEPTING THIS DRAWING FOR REFERENCE, THE RECIPIENT AGREES TO HOLD AERO DESIGN LTD. HARMLESS FROM THE USE, OR MISUSE, OF THIS DRAWING OR THE INFORMATION CONTAINED THEREON.

REV	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE – CREATED FROM 94012 REVISION 1	BJC	04/02/2016

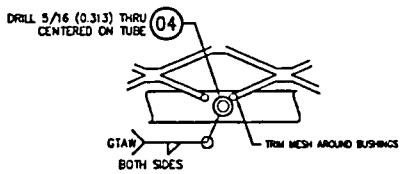


(05) COVER

HOLE LOCATIONS TO MATCH BUSHINGS IN LID



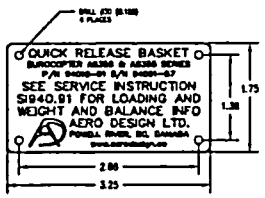
BOTTOM VIEW (03) MESH



DETAIL C

SCALE 1:1

TYPICAL, ALL BUSHING LOCATIONS

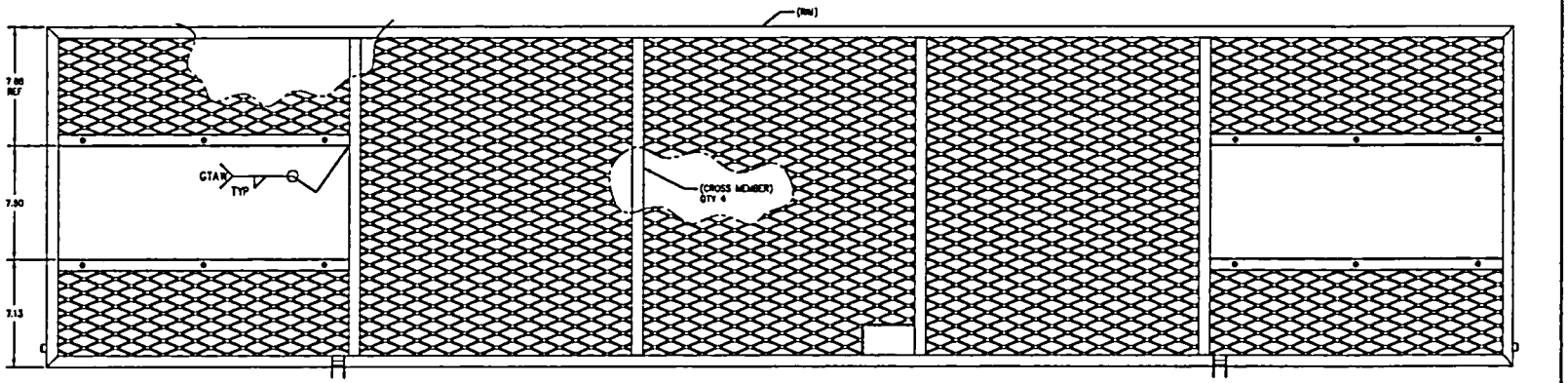


(06) PLACARD

SCALE 1:1



END VIEW



TOP VIEW

(01) LID ASSEMBLY

NOTES:

1. THIS DRAWING IS A MODIFICATION TO INCORPORATE OPENINGS IN THE LID TO PROVIDE ACCESS PORTS FOR SURVEY EQUIPMENT. REMAINDER OF CONTRUCTION REMAINS IN ACCORDANCE WITH DRAWING 94012, REVISION 1. INSTALL PLACARD (ITEM 06) ADJACENT TO PLACARD 94027-01.
2. LID MAY BE MODIFIED WITH A WALKWAY ON THE UNMODIFIED BAYS IN ACCORDANCE WITH DRAWING 70405, REVISION 4, AND MAY BE ALIGNED WITH THE CUTOUT SUPPORTS.
3. COVERS (05) TO BE INSTALLED USING AN3 BOLTS, NAS1149F0363P WASHERS, MS21044N3 NUTS IN ALL LOCATIONS PROVIDED AFTER FINISH IS APPLIED.
4. REMOVE ALL BURRS AND BREAK SHARP EDGES.
5. PRIOR TO WELDING, DRILL Ø30 (0.129) VENT HOLES IN ASSEMBLY FOR VENTING OF WELD GASES. WHEN ASSEMBLY IS COMPLETE, FILL ALL EXPOSED VENT HOLES WITH ROSETTE WELD.
6. WELDING OF 4130 STEEL TO BE COMPLETED BY GTAW METHOD TO AWS 2685C. 4130 AND 1018 STEEL: WELDING ROD SHALL CONFORM TO ER70S-2 OR EQUIVALENT.
7. THOROUGHLY DEGREASE AND POWDER COAT BASKET ASSEMBLY AFTER WELDING. THOROUGHLY DEGREASE AND POWDER COAT COVERS.

QTY	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
			LIST OF MATERIALS			
12	MS21044N3		NUT			
24	NAS1149F0363P		WASHER			
12	AN3-12A		BOLT			
1	94092-06	06	PLACARD	6061-T6 ALUMINUM	QQ-A-250/11	0.050 SHEET
3	94092-05	05	COVER	6061-T6 ALUMINUM	QQ-A-250/11	0.125 SHEET
12	94092-04	04	BUSHING	4130 STEEL COND N	MIL-T-6736	0.313 X 0.056 RND TUBE
A/R	3/4 – 16F	03	MESH	MILD STEEL	COMMERCIAL	
A/R	--	02	SQUARE TUBE	4130 STEEL COND N	MIL-T-6736	0.75 X 0.035 SQR TUBE
	94092-01	01	LID ASSEMBLY			

APPROVALS		DATE
DRAWN	JEFF CLARKE	04 FEB 2016
CHECKED	JASON REKVE	04 FEB 2016

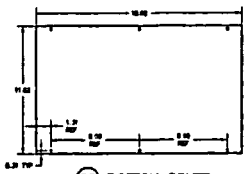
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON:

DECIMALS	ANGLES
X.XXX ±0.010	±1/2°
X.XX ±0.03	
X.X ±0.1	

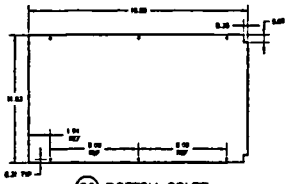
AERO DESIGN LTD.
8686A MALASPINA ROAD
POWELL RIVER, BC, CANADA, V8A 0G3
TEL: 604.485.2970 www.aerodesign.ca

AIRBUS HELICOPTERS AS350 & AS355 SERIES
QUICK RELEASE CARGO BASKET
LID MODIFICATION

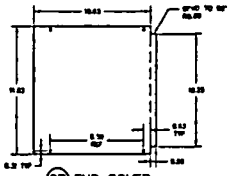
SCALE 1 : 4	DWG. SIZE	DWG. NO.	REV.
SHEET 1 OF 1	A1	94092	0



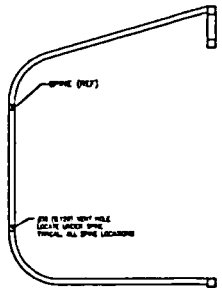
(05) BOTTOM COVER



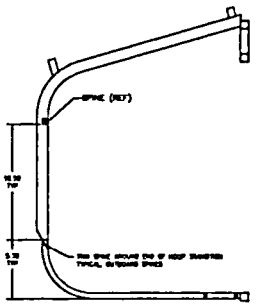
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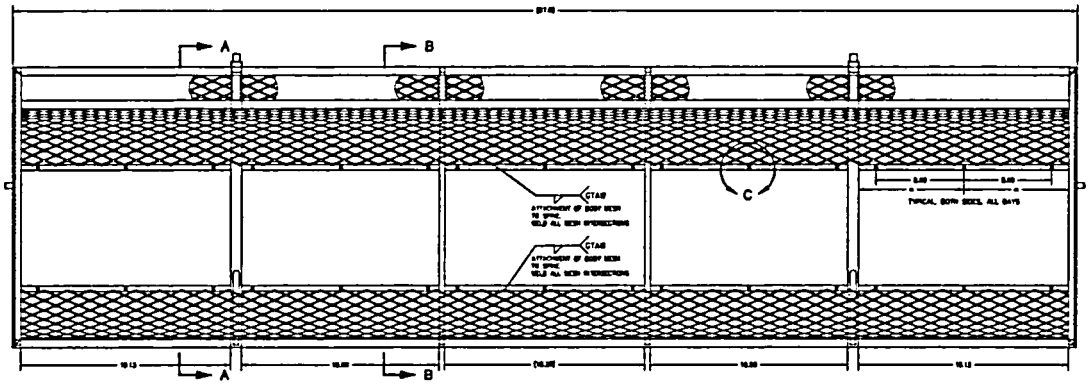
(07) END COVER



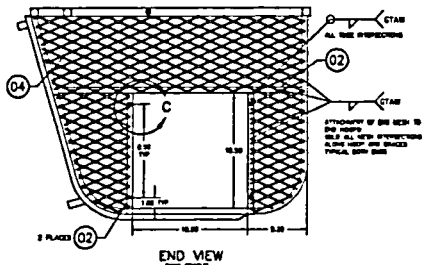
SECTION B-B



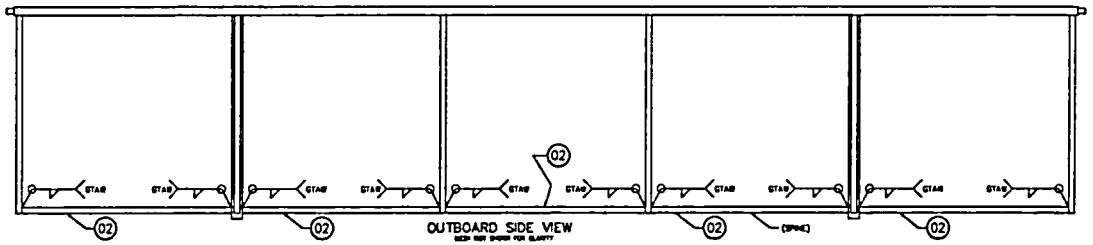
SECTION A-A



TOP VIEW

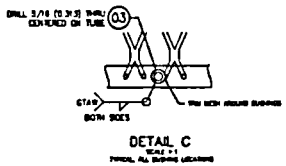


END VIEW



OUTBOARD SIDE VIEW

(01) BASKET BODY ASSEMBLY



DETAIL C

NOTES:

1. THIS DRAWING IS A MODIFICATION TO INCORPORATE GROMMETS IN THE BASKET TO PROVIDE VENT POINTS FOR SURVEY EQUIPMENT. REMAINDER OF CONSTRUCTION REMAINS IN ACCORDANCE WITH DRAWING 94091, REVISION L.
2. LOAD TESTING IN ACCORDANCE WITH ENGINEERING REPORT 94091-01, REVISION A, MUST BE COMPLETED TO DEMONSTRATE STRUCTURAL INTEGRITY OF THE MODIFIED ASSEMBLY.
3. COVERS (NS, 05, 07) TO BE INSTALLED USING (NS) BOLTS, MS51140F1052P GROMMETS, (NS)(NS) NUTS IN ALL LOCATIONS PROVIDED AFTER PAINT IS APPLIED.
4. REMOVE ALL BURRS AND BREAK SHARP EDGES.
5. PRIOR TO WELDING, DRILL .250 (6.350) VENT HOLES IN ASSEMBLY FOR VENTING OF WELD GASES. EACH ASSEMBLY IS COMPLETE, FILL ALL EXPOSED VENT HOLES WITH ROSETTE WELD.
6. WELDING OF 4130 STEEL TO BE COMPLETED BY STICK METHOD TO AWS D1.1.
7. THOROUGHLY DEGREASE AND POWDER COAT BASKET ASSEMBLY AFTER WELDING. THOROUGHLY DEGREASE AND POWDER COAT GROMMETS.

ITEM	QTY	PART NO.	DESCRIPTION	MATERIAL/FINISH	MATERIAL SPEC	STOCK SIZE
10		94091-01-01	WELD			
9	1	94091-01-09	WELDMENT, SIDE			
8		AN3-10A	BOLT			
7		AN3-10A	BOLT			
6		AN3-11A	BOLT			
5	1	94091-07	END COVER	6061-T6 ALUMINUM	QQ-A-250/11	0.040 SHEET
4	1	94091-06	BOTTOM COVER	6061-T6 ALUMINUM	QQ-A-250/11	0.125 SHEET
3	1	94091-05	BOTTOM COVER	6061-T6 ALUMINUM	QQ-A-250/11	0.125 SHEET
2	AR	3/8 - 16P	NUT	NAS 1291		
1	AR	94091-02	WELDMENT, SIDE	4130 STEEL	CONFORM TO	
30		94091-04	TUBE, BUMPER	4130 STEEL CONF. TO	MIL-T-6736	O.D. 1.315 X 0.049 WALL TUBE
29			TUBE, BUMPER	4130 STEEL CONF. TO	MIL-T-6736	O.D. 1.315 X 0.049 WALL TUBE
28		94091-03	WELDMENT, BACK			
ITEM	QTY	PART NO.	DESCRIPTION	MATERIAL/FINISH	MATERIAL SPEC	STOCK SIZE

LIST OF MATERIALS

APPROVALS	NAME	DATE
DRAWN	JEFF CLARKE	04 FEB 2016
CHECKED	JASON KEEVE	04 FEB 2016

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON: DECIMALS ANGLES X.XXX ±0.010 ±1/2° X.XX ±0.03 X.X ±0.1

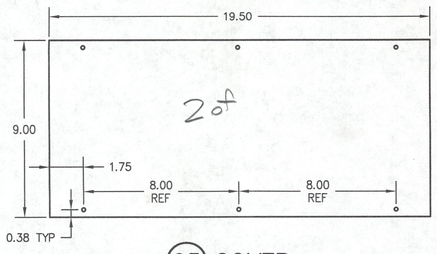
AERO DESIGN LTD.

AIRBUS HELICOPTERS AS350 & AS355 SERIES QUICK RELEASE CARGO BASKET MODIFICATION

SCALE 1 : 6 | SHEET 1 OF 1 | SIZE A0 | DWG NO. 94091 | REV 0

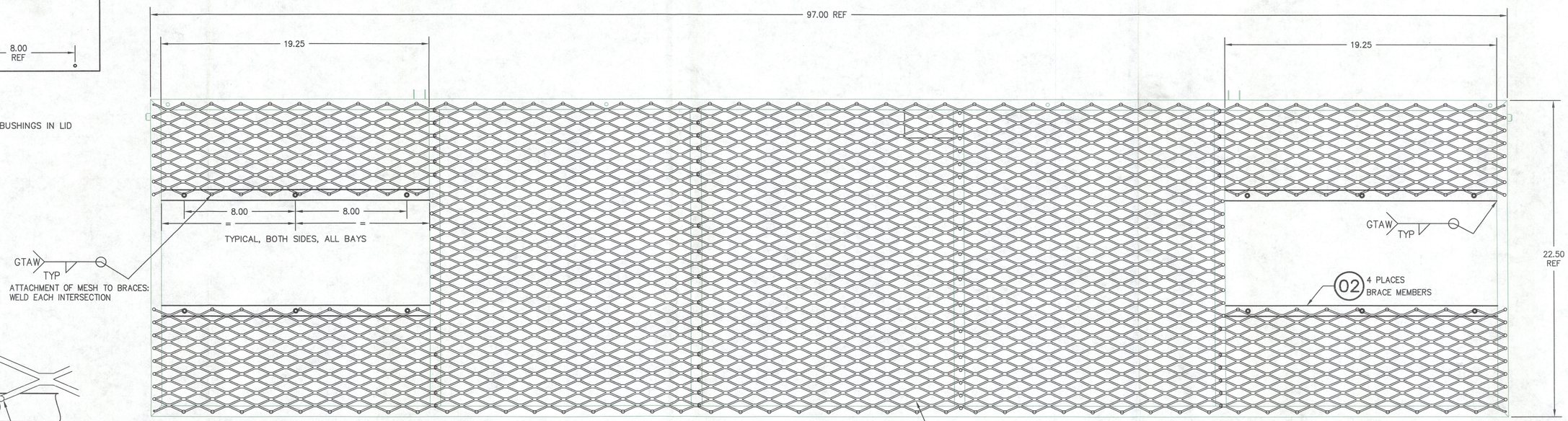
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REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		
1	TITLE BLOCK UPDATED; CHANGED 36273-01 TO 84263-01; ITEM #'S ADDED	BJC	10/07/2014
	WELDING ROD UPDATED; # OF WELDS DOWN BRACE TUBES INCREASED		



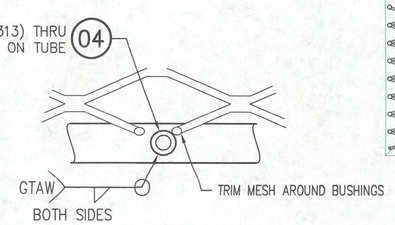
05 COVER

HOLE LOCATIONS TO MATCH BUSHINGS IN LID



BOTTOM VIEW

03 MESH



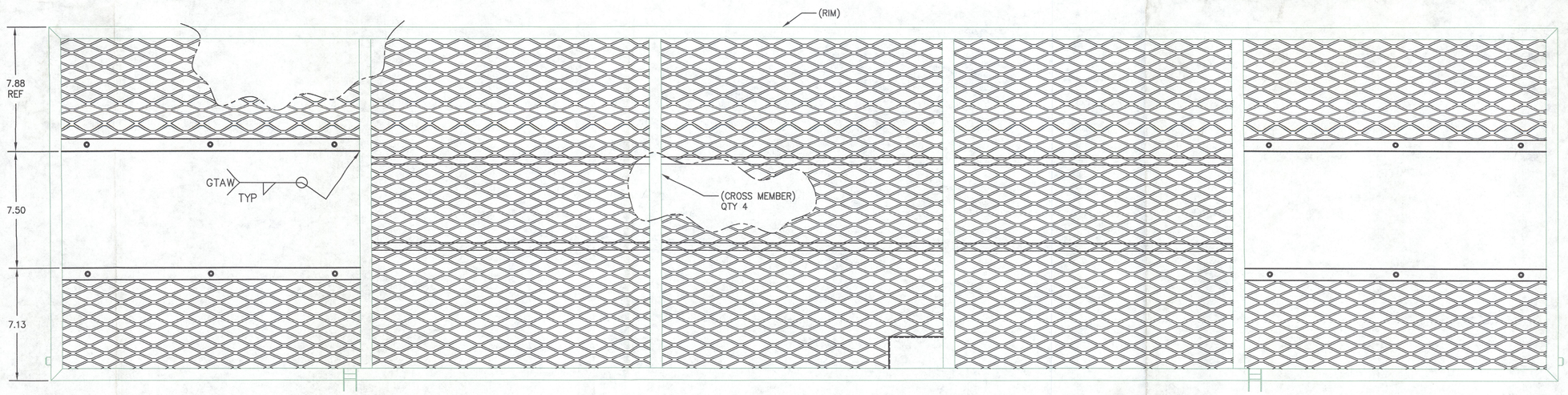
DETAIL C

SCALE 1:1

TYPICAL, ALL BUSHING LOCATIONS



END VIEW



TOP VIEW

01 LID ASSEMBLY

NOTES:

1. THIS DRAWING IS A MODIFICATION TO INCORPORATE OPENINGS IN THE LID TO PROVIDE ACCESS PORTS FOR SURVEY EQUIPMENT. REMAINDER OF CONTRUCTION REMAINS IN ACCORDANCE WITH DRAWING 94012, REVISION 1.
2. LID MAY BE MODIFIED WITH A WALKWAY ON THE UNMODIFIED BAYS IN ACCORDANCE WITH DRAWING 70405, REVISION 4, AND MAY BE ALIGNED WITH THE CUTOUT SUPPORTS.
3. COVERS (05) TO BE INSTALLED USING AN3 BOLTS, NAS1149F0363P WASHERS, MS21044N3 NUTS IN ALL LOCATIONS PROVIDED AFTER FINISH IS APPLIED.
4. REMOVE ALL BURRS AND BREAK SHARP EDGES
5. PRIOR TO WELDING, DRILL #30 (0.129) VENT HOLES IN ASSEMBLY FOR VENTING OF WELD GASES. WHEN ASSEMBLY IS COMPLETE, FILL ALL EXPOSED VENT HOLES WITH ROSETTE WELD.
6. WELDING OF 4130 STEEL TO BE COMPLETED BY GTAW METHOD TO AMS 2685C.
 4130 AND 1018 STEEL: WELDING ROD SHALL CONFORM TO ER70S-2 OR EQUIVALENT.
7. THOROUGHLY DEGREASE AND POWDER COAT BASKET ASSEMBLY AFTER WELDING.
 THOROUGHLY DEGREASE AND POWDER COAT COVERS.

QTY	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
	LIST OF MATERIALS					
12	MS21044N3		NUT			
24	NAS1149F0363P		WASHER			
12	AN3-12A		BOLT			
2	84263-01	05	COVER	6061-T6 ALUMINUM	QQ-A-250/11	0.050 SHEET
12	94092-04	04	BUSHING	4130 STEEL COND. N	MIL-T-6736	0.313 X 0.058 RND TUBE
A/R	3/4 - 16F	03	MESH	MILD STEEL	COMMERCIAL	
A/R	--	02	SQUARE TUBE	4130 STEEL COND. N	MIL-T-6736	0.75 X 0.035 SQR TUBE
	94092-01	01	LID ASSEMBLY			

APPROVALS		DATE
DRAWN:	JEFF CLARKE	03 JAN ~~2015~~ 2016 JC
CHECKED:	JASON REKVE	04 Jan 2016

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES.
TOLERANCES ON:
DECIMALS X.XXX ±0.010, X.XX ±0.03, X.X ±0.1
ANGLES ±1/2°

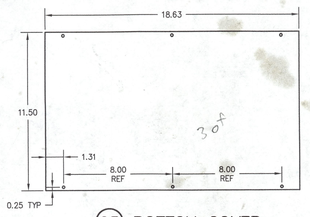
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TEL: 604.483.2376 www.aerodesign.ca

AIRBUS HELICOPTERS AS350 & AS355 SERIES
QUICK RELEASE CARGO BASKET
LID ~~ASSEMBLY~~ MODIFICATION JC

SCALE	DWG. SIZE	DWG. NO.	REV.
1 : 4	A1	94092	0
SHEET 1 OF 1			

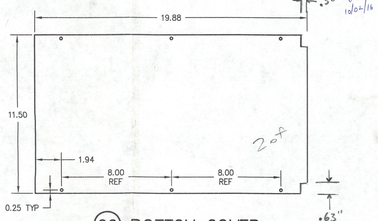
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REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE – CREATED FROM 94011 REVISION 1	BJC	03/01/2016



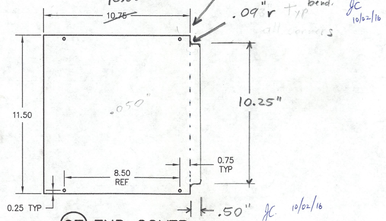
(05) BOTTOM COVER

HOLE LOCATIONS TO MATCH BUSHINGS IN BASKET



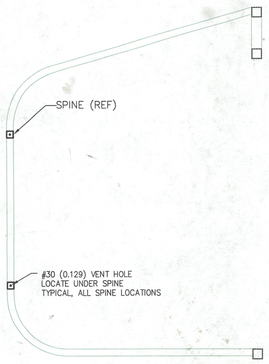
(06) BOTTOM COVER

HOLE LOCATIONS TO MATCH BUSHINGS IN BASKET



(07) END COVER

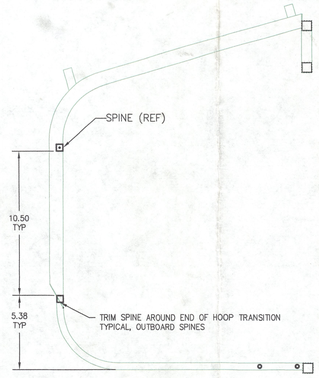
HOLE LOCATIONS TO MATCH BUSHINGS IN BASKET



SECTION B–B

SCALE 1:4

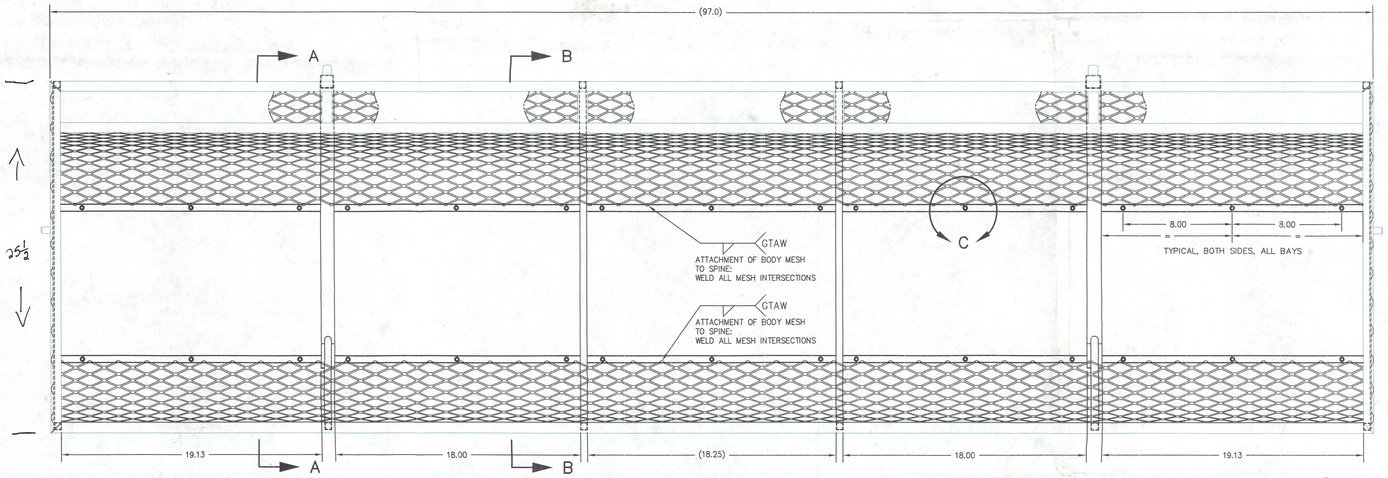
SECTION TYP 4 PLACES



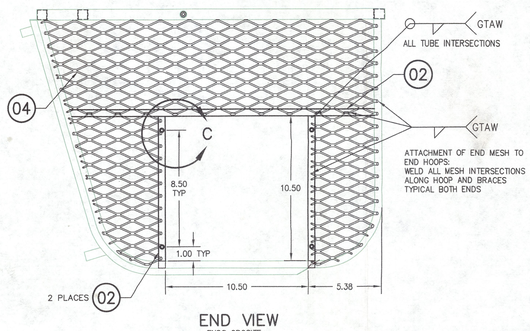
SECTION A–A

SCALE 1:4

SECTION TYP 2 PLACES

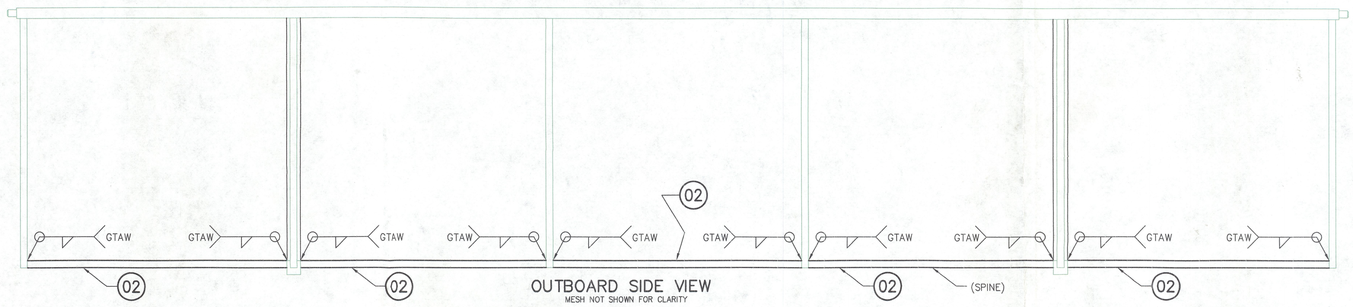


TOP VIEW



END VIEW

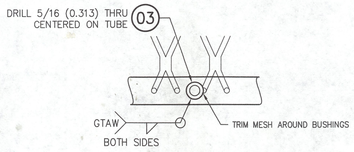
ENDS OPOSITE



OUTBOARD SIDE VIEW

MESH NOT SHOWN FOR CLARITY

(01) BASKET BODY ASSEMBLY



DETAIL C

SCALE 1:1

TYPICAL, ALL BUSHING LOCATIONS

NOTES:

1. THIS DRAWING IS A MODIFICATION TO INCORPORATE OPENINGS IN THE BASKET TO PROVIDE VIEW PORTS FOR SURVEY EQUIPMENT. REMAINDER OF CONTRUCTION REMAINS IN ACCORDANCE WITH DRAWING 94011, REVISION 1.
2. LOAD TESTING IN ACCORDANCE WITH ENGINEERING REPORT ER940.91, REVISION 0, MUST BE COMPLETED TO DEMONSTRATE STRUCTURAL STRENGTH OF THE MODIFIED ASSEMBLY.
3. COVERS (05, 06, 07) TO BE INSTALLED USING AN3 BOLTS, NAS1149F0363P WASHERS, MS21044N3 NUTS IN ALL LOCATIONS PROVIDED AFTER FINISH IS APPLIED.
4. REMOVE ALL BURRS AND BREAK SHARP EDGES
5. PRIOR TO WELDING, DRILL #30 (0.129) VENT HOLES IN ASSEMBLY FOR VENTING OF WELD GASES. WHEN ASSEMBLY IS COMPLETE, FILL ALL EXPOSED VENT HOLES WITH ROSETTE WELD.
6. WELDING OF 4130 STEEL TO BE COMPLETED BY GTAW METHOD TO AMS 2685C.
 4130 AND 1018 STEEL: WELDING ROD SHALL CONFORM TO ER70S–2 OR EQUIVALENT.
7. THOROUGHLY DEGREASE AND POWDER COAT BASKET ASSEMBLY AFTER WELDING.
 THOROUGHLY DEGREASE AND POWDER COAT COVERS.

QTY	PART NO.	ITEM	DESCRIPTION	MATERIAL/NOTE	MATERIAL SPEC	STOCK SIZE
	94091–01	01	BASKET BODY ASSEMBLY			
A/R	––	02	SQUARE TUBE	4130 STEEL COND. N	MIL–T–6736	0.5 X 0.035 SQR TUBE
.38	84272–01	03	BUSHING	4130 STEEL COND. N	MIL–T–6736	0.313 X 0.058 RND TUBE
A/R	3/4 – 16F	04	MESH	MILD STEEL	COMMERCIAL	
2	94091–05	05	BOTTOM COVER	6061–T6 ALUMINUM	QQ–A–250/11	0.125 SHEET
2	94091–06	06	BOTTOM COVER	6061–T6 ALUMINUM	QQ–A–250/11	0.125 SHEET
2	94091–07	07	END COVER	6061–T6 ALUMINUM	QQ–A–250/11	0.050 SHEET
30	AN3–11A		BOLT			
8	AN3–10A		BOLT			
76	NAS1149F0363P		WASHER			
.38	MS21044N3		NUT			

LIST OF MATERIALS

APPROVALS		DATE
DRAWN:	JEFF CLARKE	03 JAN 2016
CHECKED:	JASON REKVE	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES.
TOLERANCES ON:

DECIMALS	ANGLES
X.XXX ±0.010	±1/2°
X.XX ±0.03	
X.X ±0.1	

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AIRBUS HELICOPTERS AS350 & AS355 SERIES
QUICK RELEASE CARGO BASKET
BASKET BODY MODIFICATION

SCALE 1 : 4	DWG. SIZE	DWG. NO.	REV.
SHEET 1 OF 1	A0	94091	0